

5/03

| | | | |
|--|--|---------------------|------------|
| DART AEROSPACE LTD | | Work Order: | 22051 |
| Description: Fitting | | Part Number: | D3299-5 |
| Dwg: D3299 Rev. <i>KAI 04.11.16</i> | | Qty: | <i>6</i> u |
| | | Page 1 of 1 | |




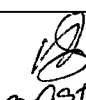

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|------------|----------|----------|
| 1 | DC | Issue Traveler | <i>HJ</i> | 04.12.08 | 2 |
| 2 | MC | Cut blank: 2.950" long Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) Identify as D3299-5 Batch: <i>115717</i> | <i>ml</i> | 05/01/04 | <i>6</i> |
| 3 | MC | Turn as per Folio FA465 and Dwg D3299 | <i>ml</i> | 05/01/05 | <i>6</i> |
| 4 | QC2 | Inspect parts as they come off the CNC machine | <i>ml</i> | 05/01/05 | <i>6</i> |
| 5 | MV | Machine as per Folio FA465 and Dwg D3299 | <i>ml</i> | 05/02/22 | <i>6</i> |
| 6 | QC2 | Inspect parts as they come off the CNC machine | <i>ml</i> | 05/02/22 | <i>6</i> |
| 7 | QC8 | Second check | <i>R</i> | 05/02/22 | <i>6</i> |
| 8 | MV | Deburr | <i>ml</i> | 05/02/22 | <i>6</i> |
| 9 | PG | Issue P/O: <i>2007621</i> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required | <i>u</i> | 05.02.23 | <i>6</i> |
| 10 | RG | Receive and Inspect for transit damage Ensure material release note is attached | <i>CL</i> | 05/02/28 | <i>6</i> |
| 11 | QC5 | Inspect work to Step 10 | <i>2</i> | 05-03-01 | <i>6</i> |
| 12 | ST | Identify and Stock <i>Identify with a Part & Batch # using a Permanent Fine Point Marker.</i> | <i>CL</i> | 05/03/02 | <i>6</i> |
| 13 | AC | Cost / part: <i>53.34</i> | <i>540</i> | 05-03-03 | <i>6</i> |
| 14 | DC | Close W/O <i>36.01</i> Inspect Level 21 | | | |

Qual 04.11.03

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 04.10.04 | New issue | KJ/JLM | <i>[Signature]</i> |

RELEASED
04.10.04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---------------------------------------|---|----------------------------------|---|--|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 05/01/05 | 3 | 1 piece scrap first piece machined |  per-05/01/05 | destroy & replace |  05/01/05 |  per-05/01/05 05/01/05 |  per-05/01/05 |  05/01/05 |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

| | | | |
|-----------------------|---------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 22051 |
| Description: Fitting | | Part Number: | D3299-5 |
| Inspection Dwg: D3299 | Rev: A1 | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------------------|------------------|--------|--------|----------------------|----------|
| 1.625 | +/-0.010 | 1.625 | ✓ | | Vern | |
| 1.250 | +/-0.010 | 1.250 | ✓ | | Vern | |
| Ø1.00 | +/-0.030 | Ø1.003 | ✓ | | Vern | |
| Ø0.560 | +0.005/-0.000 | Ø0.560 | ✓ | | Vern | |
| Ø0.313 ±0.002 | +0.005/-0.000 | Ø0.307 | ✓ | | Vern | |
| 0.083 | +0.015/-0.000 | 0.086 | ✓ | | Vern | |
| 30° | +/-0.5° | 30° | ✓ | | Protractor | |
| 53° | +/-0.5° | 53° | ✓ | | Protractor | |
| 1.00 | +/-0.030 | 1.001 | ✓ | | Vern | |
| 1.700 | +/-0.010 | 1.699 | ✓ | | Vern | |
| R0.06 | +/-0.030 | R0.060 | ✓ | | R-6 | |
| Ø0.476 | +0.000/-0.005 | Ø0.475 | ✓ | | Vern | |
| MOW for 9/16"-18 | Min = 0.5653 Max = 0.573 | 0.573 | ✓ | | Micr | |
| 0.20 | +/-0.030 | 0.187 | ✓ | | Vern | |
| 0.93 | +/-0.030 | 0.930 | ✓ | | Vern | |
| 0.150 | +/-0.010 | 0.152 | ✓ | | Vern | |
| Ø0.688 | +/-0.010 | Ø0.688 | ✓ | | Vern | |
| Ø0.580 | +0.005/-0.000 | Ø0.581 | ✓ | | Vern | |
| 0.50 | +/-0.030 | 0.500 | ✓ | | Vern | |
| 2.85 | +/-0.030 | 2.850 | ✓ | | Vern | |

| | | | |
|------------------------|----------------------|---------------------|-----|
| Measured by: <i>me</i> | Audited by: <i>R</i> | Prototype Approval: | N/A |
| Date: 05/01/05 | Date: 05.02.22 | Date: | N/A |

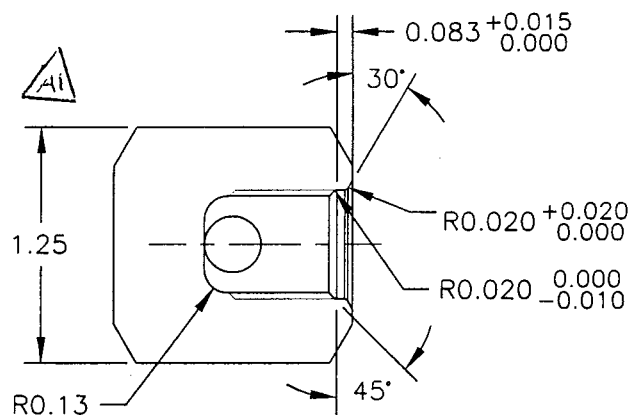
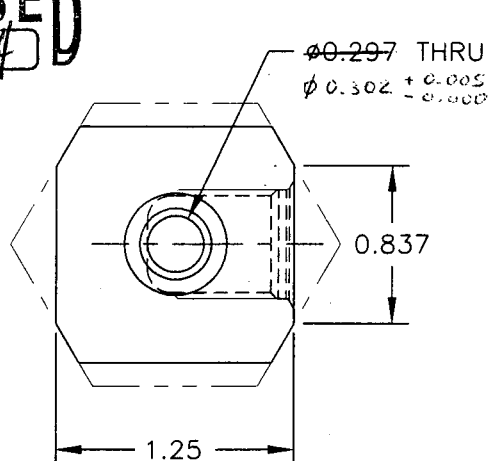
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 04.11.12 | New Issue | KJ/JLM | <i>[Signature]</i> |

RELEASED
05/01/11/15

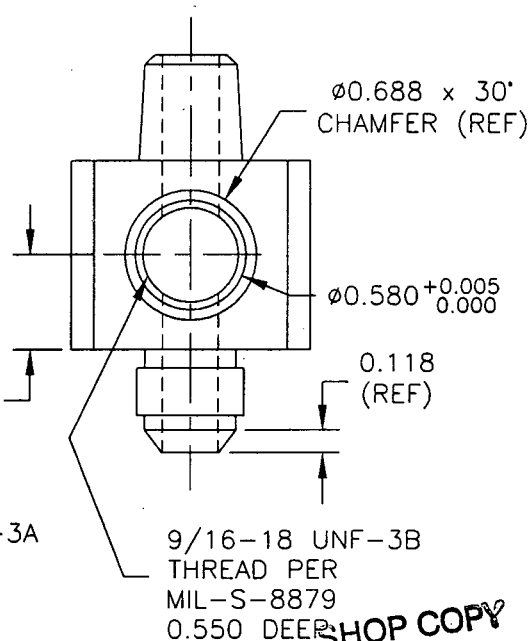
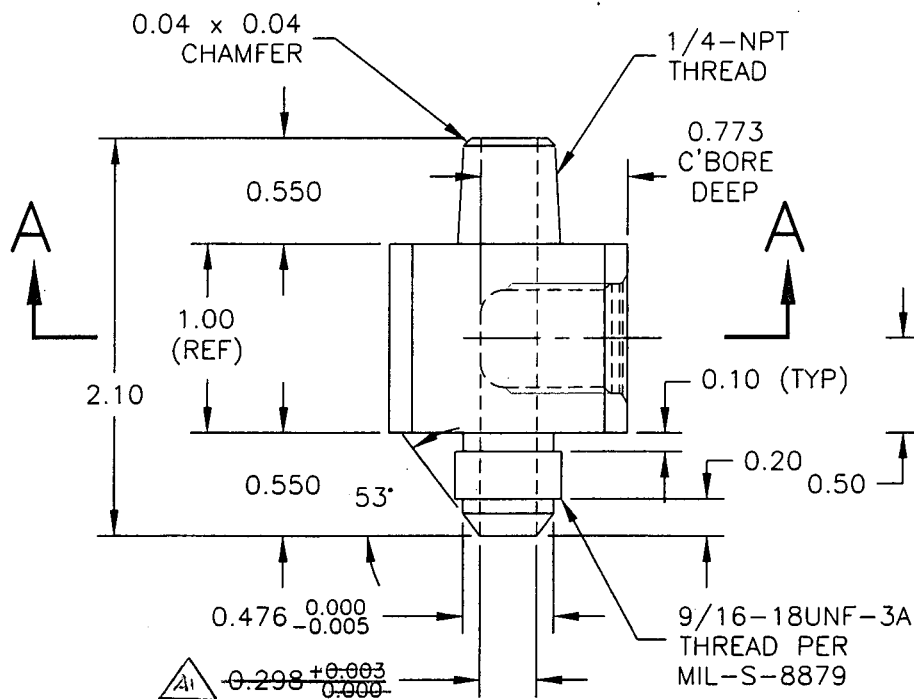


| | | | | | |
|----------|----------|------------------------------------|--|---|--|
| DESIGN | | DRAWN BY | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | APPROVED | | DRAWING NO. REV. A | |
| 04.07.06 | | 04.07.06 | | D3299 SHEET 1 OF 3 | |
| DATE | | TITLE | | SCALE | |
| 04.07.06 | | FITTING | | 1:1 | |
| A | 04.07.06 | NEW ISSUE | | | |
| AI | 04.11.15 | 0.302 WAS 0.297; ADD 0.540% R.O.13 | | | |

RELEASED



SECTION A-A



D3299-1

79
ER SHOP COPY

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (MIL-STD-883C)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR III
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

RETURN TO
ENGINEERING

ENGINEERING
6061T6H1.625)
LIB CLASS (2) LLED COPY
AMENDMENT
S
ICE

2205

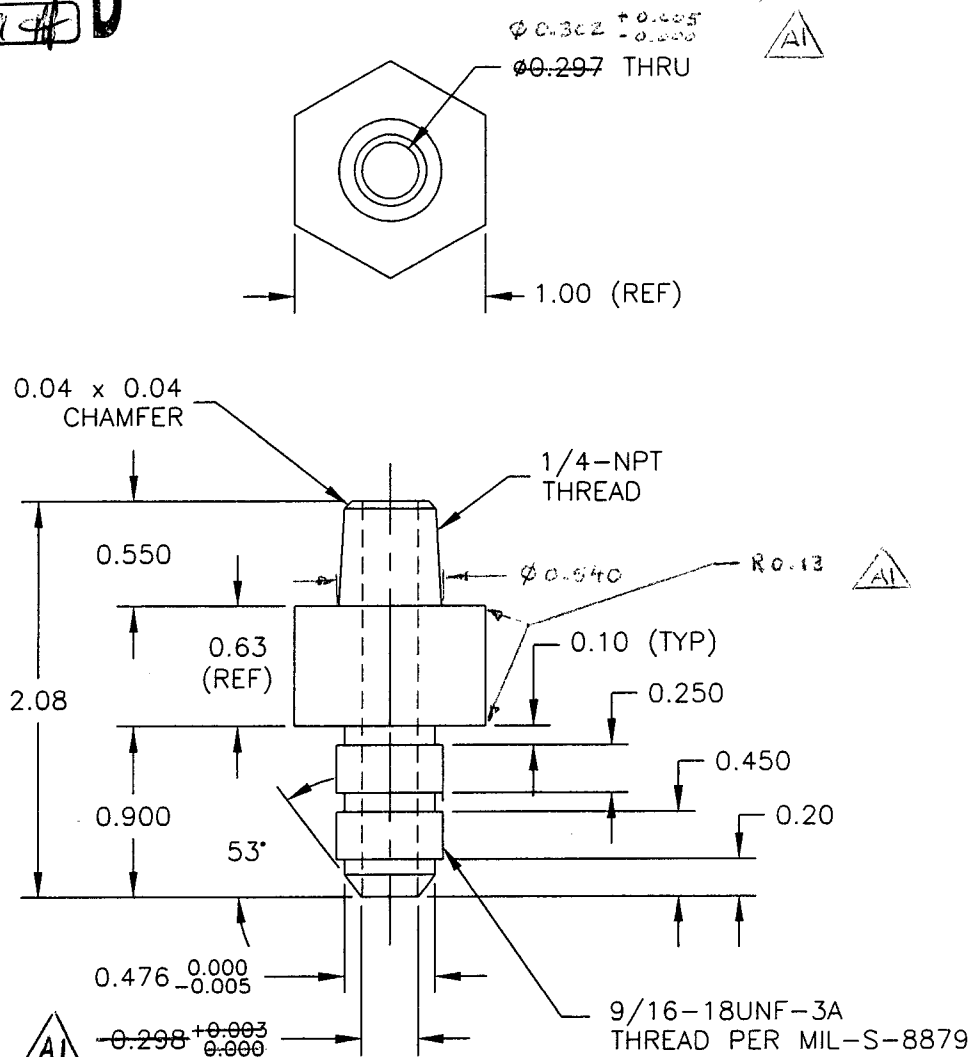
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| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>RT</i> | DRAWN BY <i>RT</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CH</i> | APPROVED <i>CH</i> | DRAWING NO. D3299 | REV. A SHEET 2 OF 3 |
| DATE 04.07.06 | | TITLE FITTING | SCALE 1:1 |

RELEASED
04.09.09 *CH*



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2.0. NOTICE
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 22051

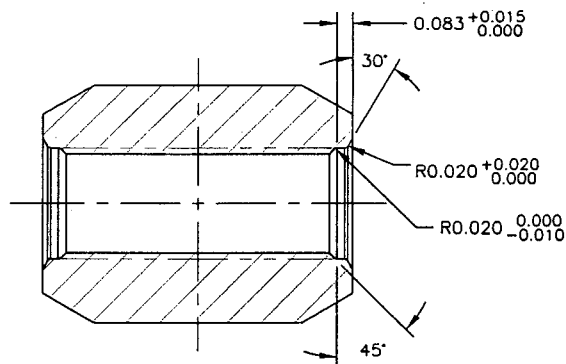
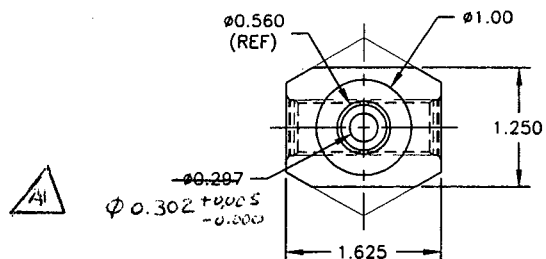
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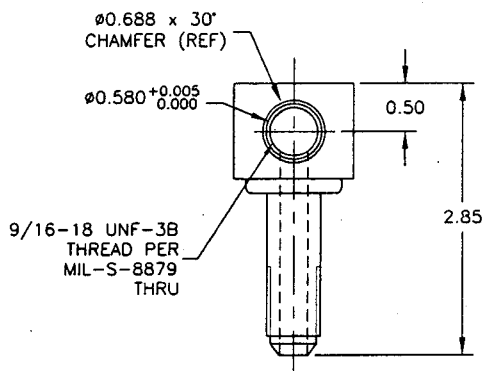
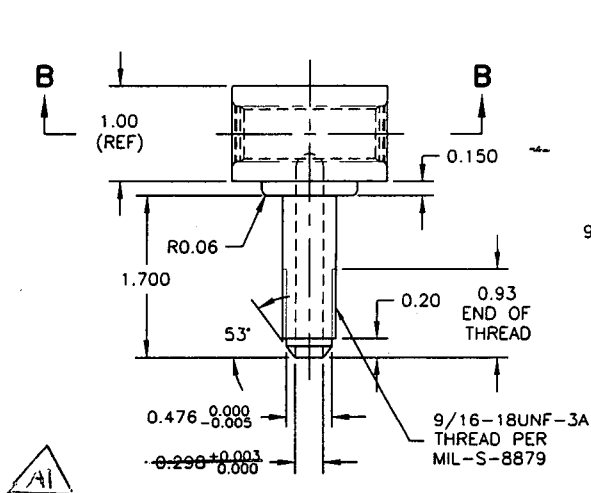


| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN RT | DRAWN BY RT | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3299 | REV. A SHEET 3 OF 3 |
| DATE 04.07.06 | | TITLE FITTING | SCALE 1:2 |

RELEASED
04.07.06 [Signature]



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TMM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022051
Project Name : D3299-5
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3299-5
Description : Fitting
Manufactured : Yes
Amount Req'd : *bu*
Amount Done : 0
Start Date : 12-03-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Margin : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |

TNM**ANODISATION et PEINTURE TNM INC.****C. OF C**

4454 Garand, Ville St. Laurent, QC H4R 2A2
Telephone: (514) 335-7001 Fax: (514) 335-3920
Certifié ISO 9001-2000 / ISO 9001-2000 certified
Certifié NADCAP / NADCAP certified

39237

25-Feb-2005

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO


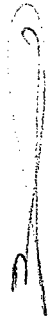
K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/
NO. DE COMMANDE: 2007621**

| ITEM | COMMANDE ORDERED | EXPEDIE SHIPPED | PART NUMBER & DESCRIPTION | | PART PROCESS & TREATMENT |
|------|---------------------|--------------------|---------------------------|--------|---|
| 1 | 9 | 9 | D3299-1 | B22049 | DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER |
| 2 | 9 | 9 | D3299-3 | B22050 | DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER |
| 3 | 6 | 6 | D3299-5 | B22051 | DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER |

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed:**Directeur de la Qualité / Q.A. Manager**